

Date Thursday, 16/08/2007 10:22:17 AM
User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACERS (1/4 THICK)
Job Number	: 33985		
Estimate Number	: 10247		
P.C. Number	: <i>NA</i>	Part Number	: D2022101
This Issue	: 16/08/2007 S.O. No. : <i>NA</i>	Drawing Number	: D2022 REV. --
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : MACHINED PARTS	Drawing Revision	: <i>NA</i>
Previous Run	: 30543	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 25/09/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>404</i> Um: Each
Comment	: Est D 02/08/07 Now made in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0329 f(s)/Unit Total: 13.1460 f(s)
6061T6 Round Bar .750"
Material: 6061-T6 (QQ-A-225/8)x.750Ø bar
(M6061T6RO.750 Batch: *103156*

*13'**RD 07/11/04*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
1- Note: .257(F) Dia drill
2-Turn Blank as per FolioFA206
3-Tumble & deburr any sharp edges as per dwg

RD 07/11/04

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*RD 07/11/04**(404)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*8F 02/11/05**(404)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST.9*

(404) 07/11/05 JS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/11/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACERS (1/4 THICK)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: D.08/11/05 (circled) 1484

Job Completion



Handwritten: U.07.11.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

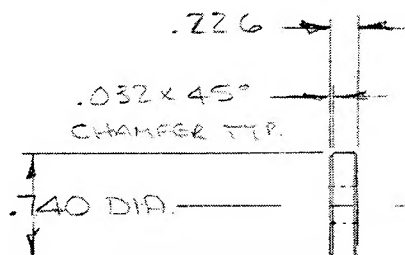
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
770119 Bu



DRILL F (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)

W/033985



2022

D2022-103		SPACER 5/16		ALUM 6061-T6		QQ-A-250/B	
D2022-101		SPACER 1/4		ALUM 6061-T6		QQ-A-250/B	

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
DART AERO ACCESSORIES INC				

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER HAS 523	ONLY REQUIRED
DRAWN		BASIC CODE	DR. DASH NO. SHOWN NEAR BOX. PNEUMATIC DASH NO.
APPROVED		D-DIMPLE DASH NO. OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SHOOTFIELD
DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES: 100 3. REMOVE SHARP EDGES: 0.015 MAX 4. THREADS PER MIL: 1-1142 5. HOLES PER AND 10001	1. TOLERANCES - AS 2. 030 2. ANGLES - 30° & 010 3. PARALLELISM - 0.005 4. ECCENTRICITY - 0.005 MAX 5. SYMMETRY ABOUT ALL MAX CENTRE LINES 0.05	BASIC CODES ALUMINUM T604 80-402042600
REPORT ALL DISCREPANCIES - DO NOT SCALE			

CONTRACT NO.	DATE	CLIENT	TITLE
BRADLEY	9/20/19		SPACERS
DESIGN			
STRESS			
CHECKED			
CLIENT			

DWG NO.	REV.
D2022	
SCALE	SHT 1 OF 1

